

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 31347		
Estimate Number	: 12788		
P.O. Number	: N/A	Part Number	: D356413
This Issue	: 3/20/2007 S.O. No. : N/A	Drawing Number	: D3564 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 31164	Material	: N/A
Written By	: [Signature]	Due Date	: 4/5/2007 Qty: 10 Um: Each
Checked & Approved By	: [Signature] 07-03-20		
Comment	: Est Rev:A New Issue 07-03-08 ec		

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1785 sf(s)/Unit Total : 1.7850 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: M101463

ml 07 03 23

10

2.0.	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3564

Dwg Rev: A

Prog Rev: A

ml 07 03 23

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

50 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT and DT

mf 07/03/30 (11)
07/03/26 (11)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:04:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31347

Part Number: D356413

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

2004-02

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

touch ups: FR 07/04/04 (2)
m/01601
FR 07/04/03 (18)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FR 7/4/4 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)
FR 07/04/05

Job Completion



u 07-04-05

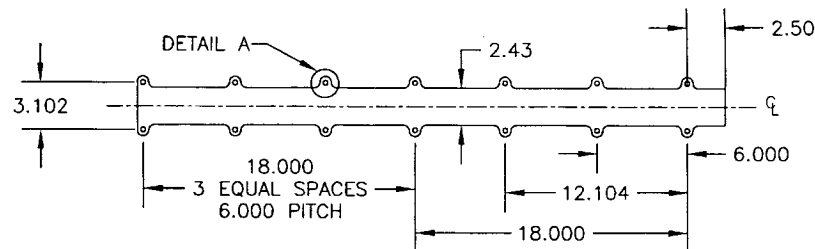
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

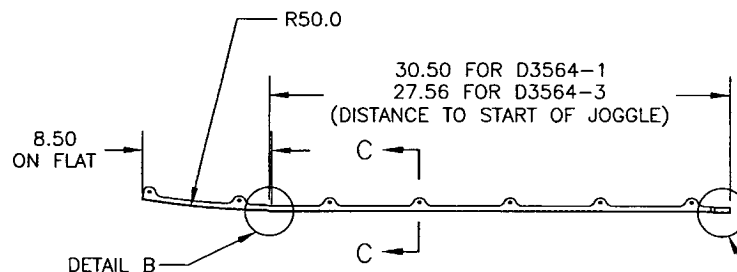
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

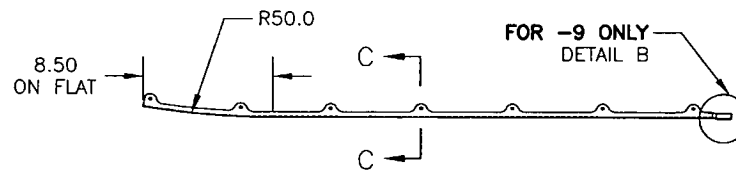
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



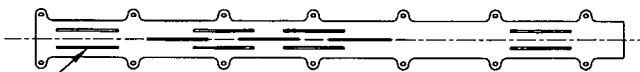
D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



FOR -1 ONLY
DETAIL B

D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED

07.07.28

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

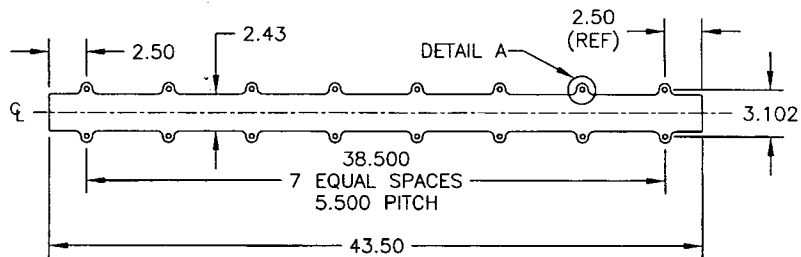
- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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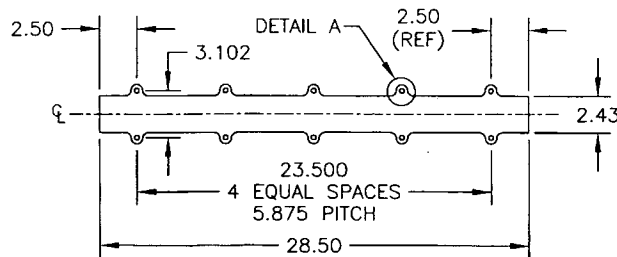
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A	06.12.18	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D3564
DATE 06.12.18	TITLE WEARSHOE	REV. A SHEET 1 OF 2 SCALE 1:8

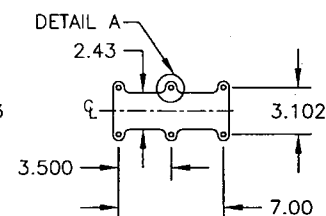
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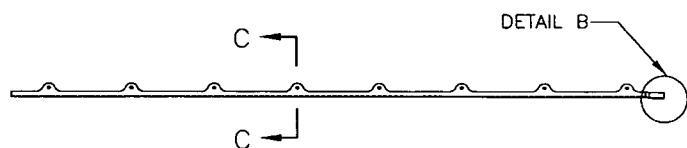
D3564-5F FLAT PATTERN



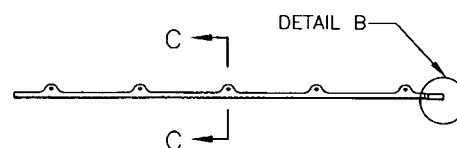
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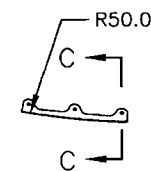
D3564-13F FLAT PATTERN



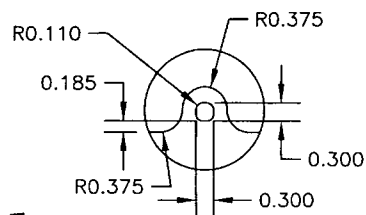
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



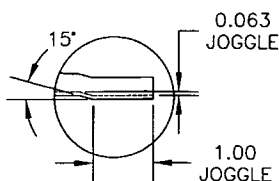
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



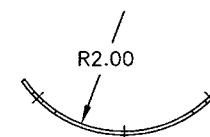
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.02.28

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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3564	REV. A SHEET 2 OF 2
DATE 06.12.18		TITLE WEARSHOE	SCALE 1:8

DART AEROSPACE LTD		Work Order: 31347
Description: Wearshoe		Part Number: D3564-13
Inspection Dwg: D3564 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	3.102	+/- 0.010	3.106	✓		VERN	
B	3.500	+/- 0.010	3.506	✓		VERN	
C	7.00	+/- 0.030	7.00	✓		MEASURING tape	
D	2.43	+/- 0.030	2.437	✓		VERN	
E	3.00X.300	+/- 0.010	0.300X0.301	✓		VERN	
F							
G							
H							
I							
J							
K							
L							
M							
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Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: M.M.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07-03-26	Date: 07/03/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	